

Work Order ID 53035

October 22, 2009 10:30:20 AM



Page 1

Item ID:	D3121-141	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Bracket Assembly					
Start Date:	21/10/2009	Start Qty:	12.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-10-22	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3121	Rev E								
100	BAND SAW	0.00				12	0		
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blanks: (1.250" x 2.000") 6.600" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00				12	0		
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 2-Deburr 3-Scribe batch number								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				12	0		
	QC	0.00							
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-141 PAR #: _____ Fault Category: Machined parts NCR: Yes No DQA: [Signature] Date: 05-11-18
 Resolution: Accepted Disposition: use as is QA: N/C Closed Date: 05-11-18

NCR: 53035		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/07	110	.280" IS .300" due to program error DIST TO SLOT R.C: program.	CP 09/11/07 481042	Acceptable ⇒ Program has been fixed and updated	M.A 09/11/07	[Signature] 09-11-07	CP 09/11/07 481042	[Signature] 09-11-07

NOTE: Date & initial all entries

Work Order ID 53035

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Item ID: D3121-141
Revision ID: E
Item Name: Bracket Assembly

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00	<i>SB 09/11/10</i>			12			
QC Quality Control	Memo	0.00							
140 	Small Fab	0.00	<i>SB 09/11/10</i>						
Small Fab	Memo	0.00							
Small Fab	Assemble D3121-141 as per Dwg D3121.								
150 	QC5- Inspect part completeness to step on W/O	0.00	<i>SB 09/11/10</i>			12	0		
QC Quality Control	Memo	0.00							

SB 09/11/10 (12)

Work Order ID 53035

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October 22, 2009 10:30:20 AM

Item ID: D3121-141
Revision ID: E
Item Name: Bracket Assembly

Accept



Setup Start



Stop



Start Date: 21/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 235

0.00



Packaging

Memo

0.00

Packaging

9/11/11 SCL

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/11 JFMF 09-11-11

Picklist Print

October 22, 2009 10:30:25 AM

Page 1

Work Order ID: 53035

Parent Item: D3121-141RevE

Parent Item Name: Bracket Assembly

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3121-241RevE Manufactured No



Bearing Assembly

100

Each

83.0000

12.0000



9/30/11/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

83

52592

83

140

Each

99.0000

12.0000



12
9/30/11/10

D3121-21RevE

Manufactured No



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

99

46032

5

50096

10

52518

84

140

f

8.7139

6.9474



12

M174B1.250X02.000

Purchased No



17-4 SS Bar 1.250 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

8.71394736

109851

1.83894736

111787

6.875

6.16 *DT 29/11/05*

DART AEROSPACE LTD		Work Order:	53035
Description: Bracket		Part Number:	D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1	

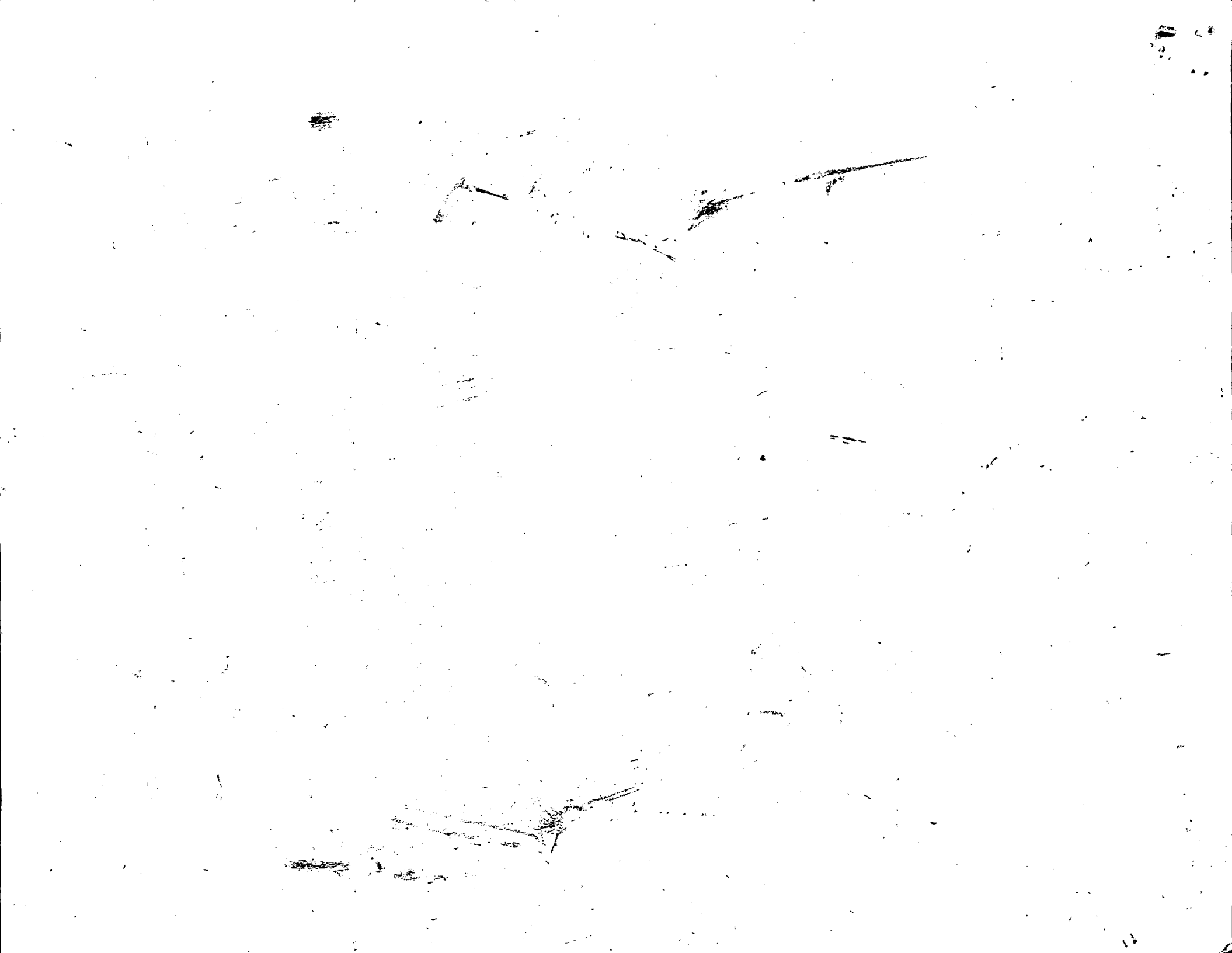
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	Ø 0.393	✓			
0.75	+/-0.030	0.751	✓			
0.375	+/-0.010	0.375	✓			
2.14	+/-0.030	2.158	✓			
1.96	+/-0.030	1.964	✓			
0.280	+/-0.010	0.290	✓			
3.330	+/-0.010	3.330	✓			
3.630	+/-0.010	3.640	✓			
R0.25	+/-0.030	R 0.250	✓			
R0.375	+/-0.010	R 0.375	✓			
Ø0.201	+0.005/-0.001	Ø 198	✓			OK, 4/09.11.09
0.100	+/-0.010	0.101	✓			
4.580	+/-0.010	4.590	✓			
6.18	+/-0.030	6.180	✓			
5.89	+/-0.030	5.886	✓			
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.300	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	R 0.250	✓			
0.130	+/-0.010	0.130	✓			
0.664	+/-0.010	0.664	✓			
0.381	+/-0.010	0.391	✓			
0.201	+/-0.010	0.199	✓			
0.400	+/-0.010	0.397	✓			
0.580	+/-0.010	0.578	✓			
100°	+/-0.1°	100°	✓			
0.032	+0.000/-0.010	0.031	✓			

Measured by: B.A	Audited by: SP	Prototype Approval:	N/A
Date: 09/11/07	Date: 09/12/10	Date:	N/A

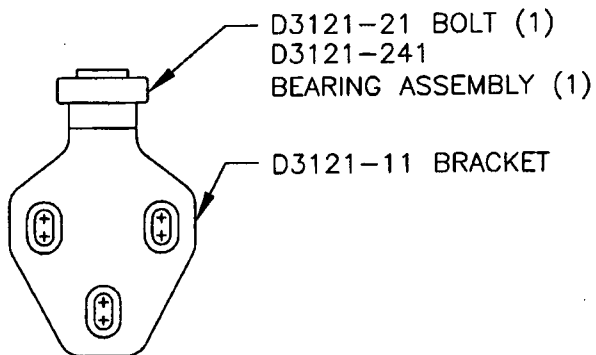
Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	





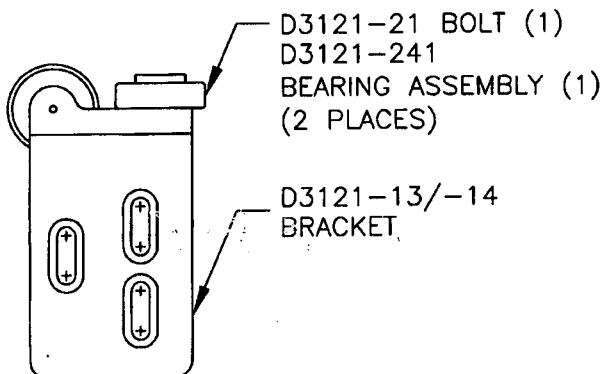
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET-ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED
07.11.07

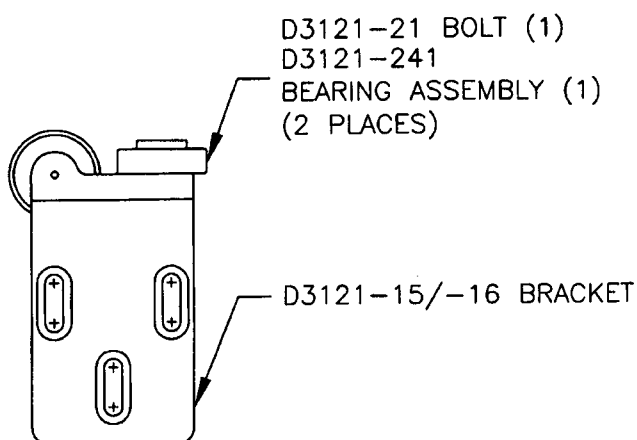


D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)

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NO. 53035
PT 09-10-21



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

D3121-111 BRACKET

RELEASED
07.11.07 *W*

D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

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D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)

D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

D3121-115/-116
BRACKET

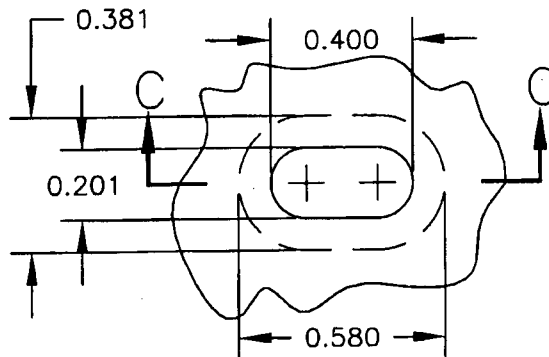
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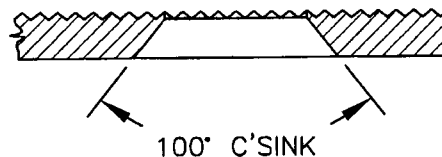


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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED

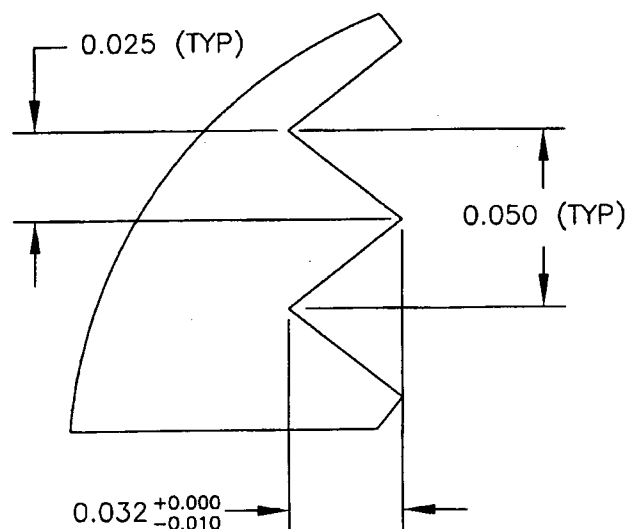


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SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



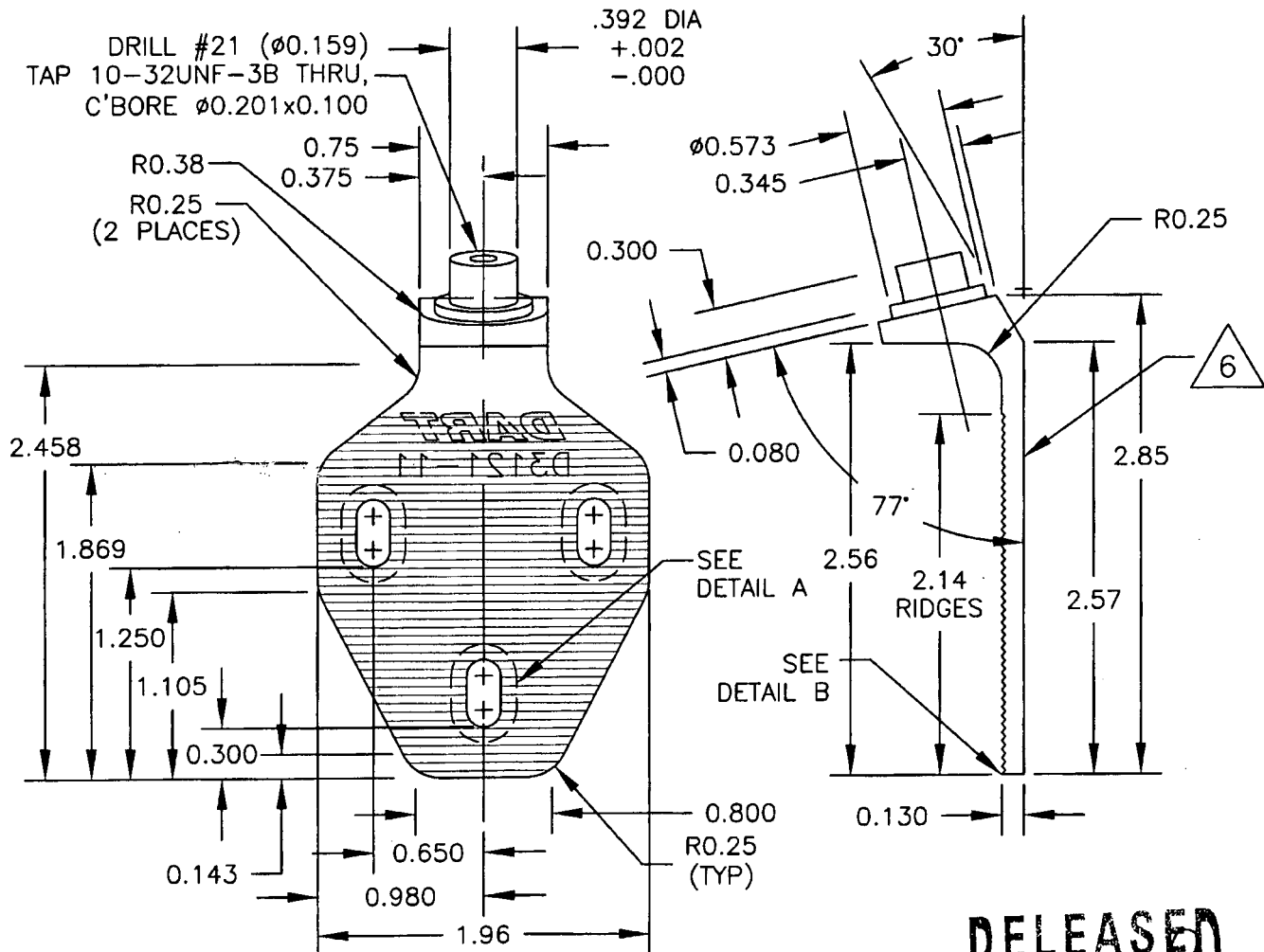
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**RELEASED**
07.11.07**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

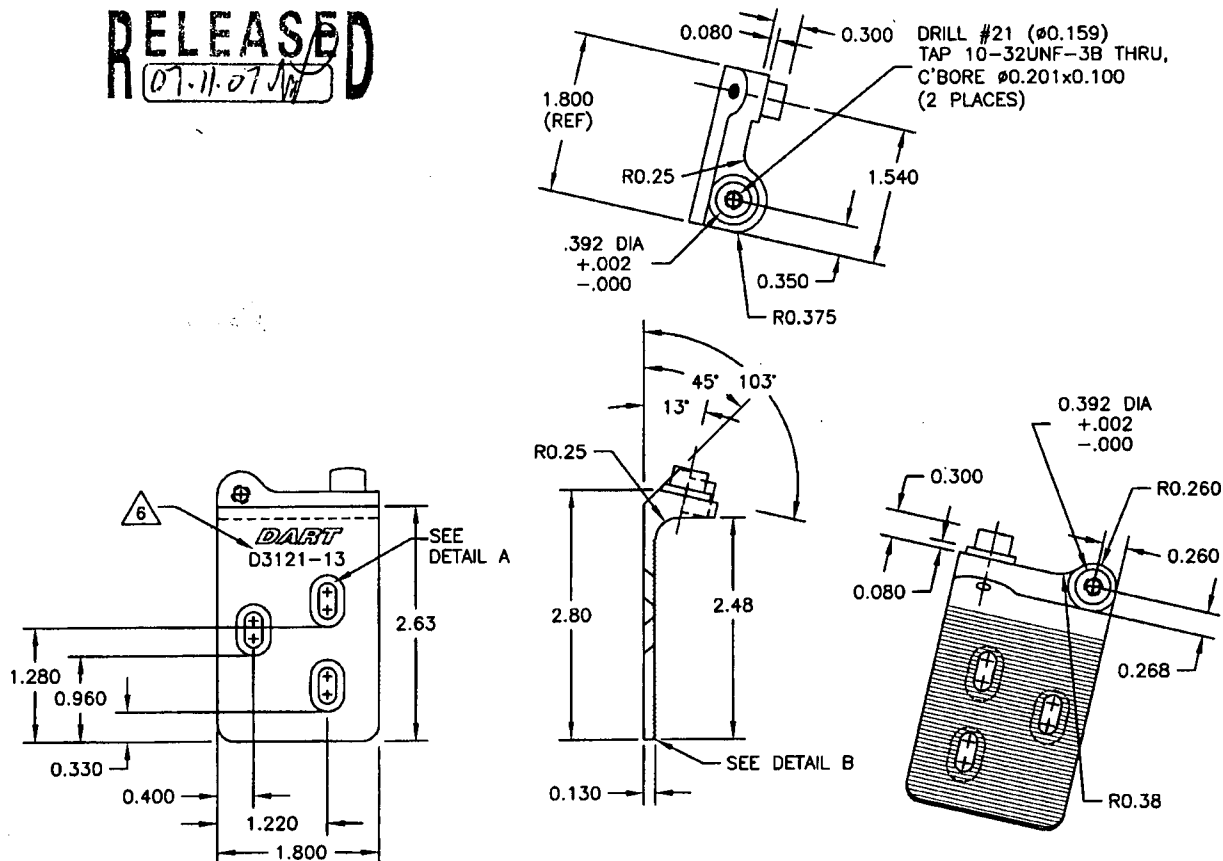
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07-11-07

D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

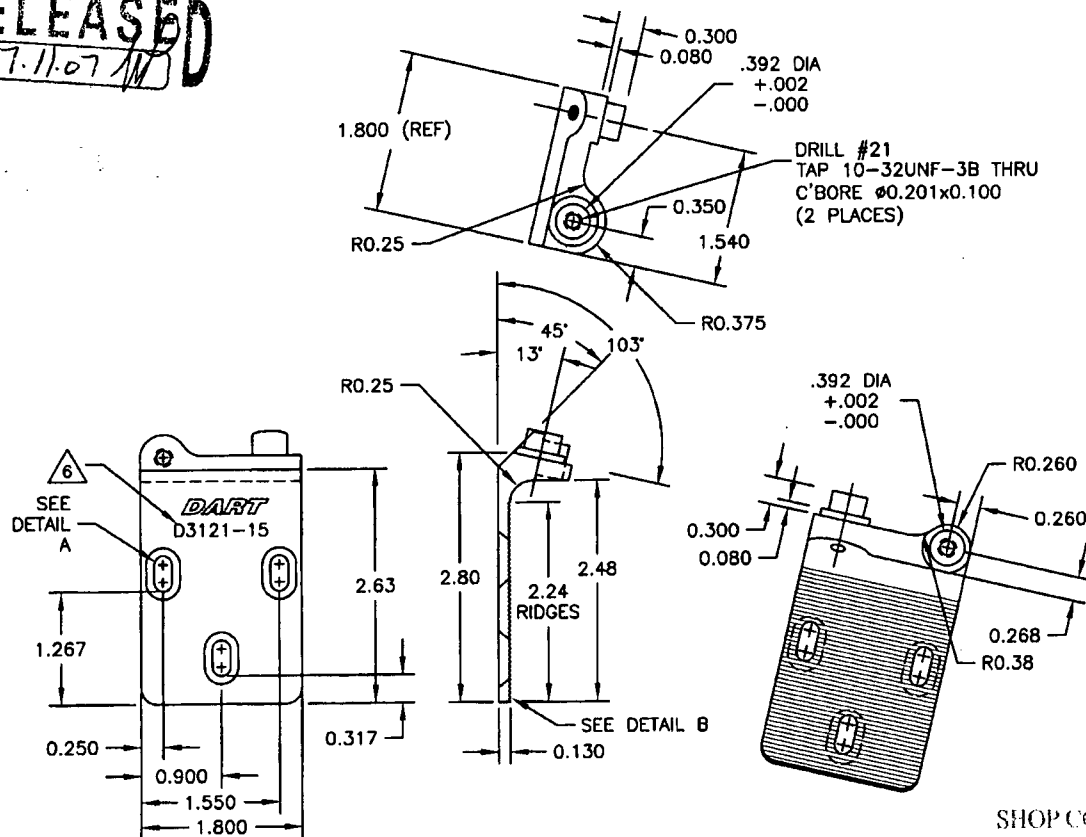
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 6 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

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07.11.07

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D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

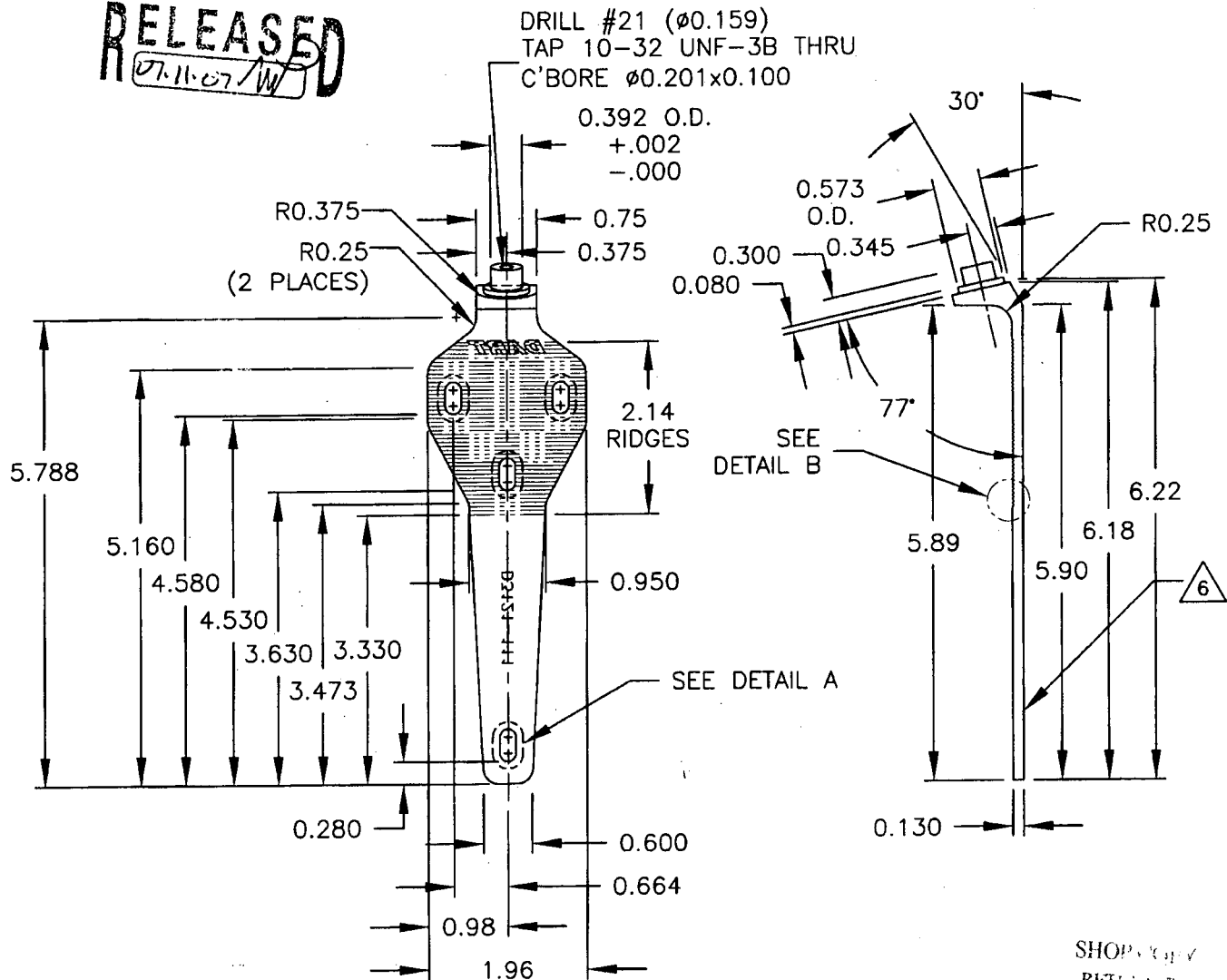
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07/W**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

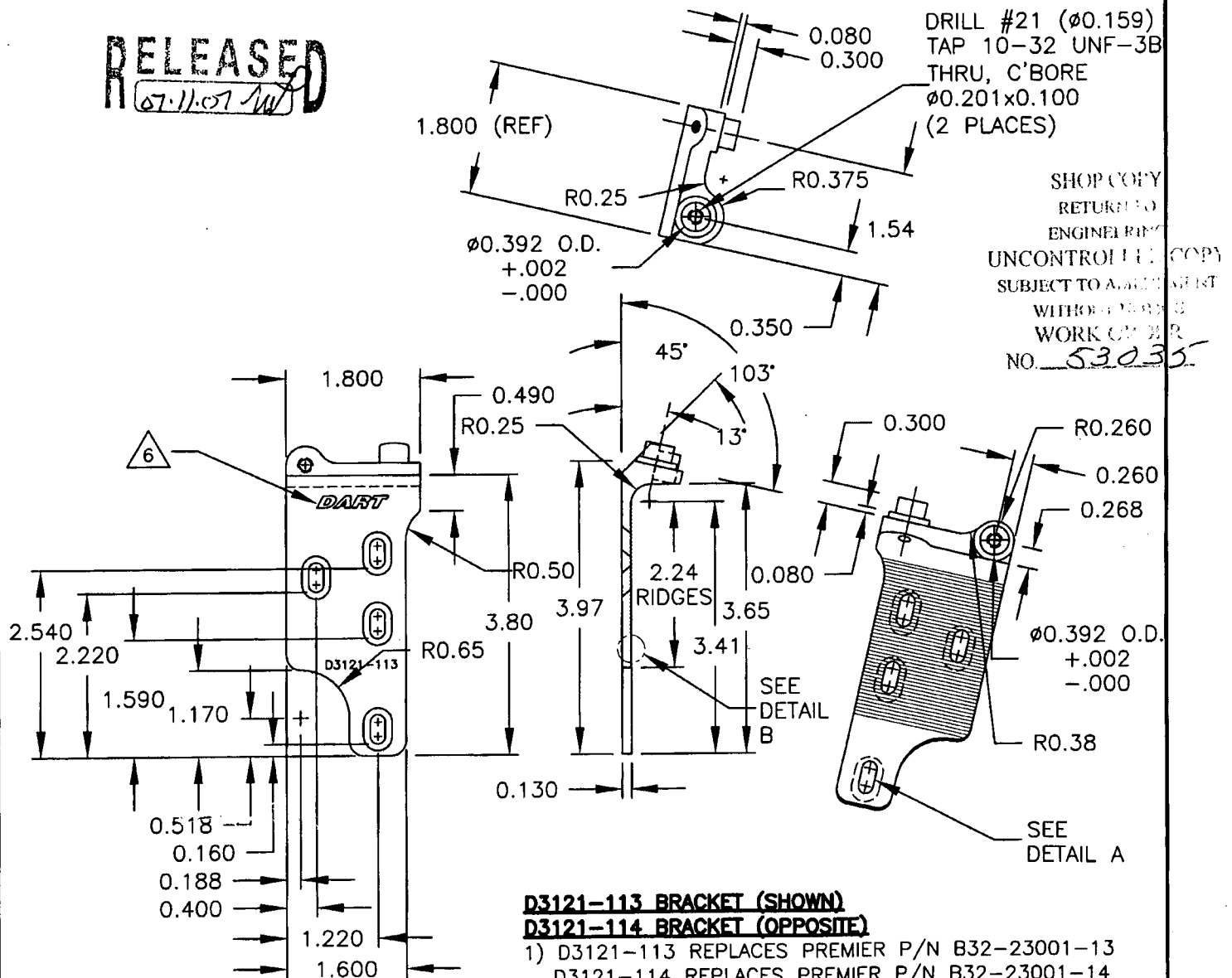
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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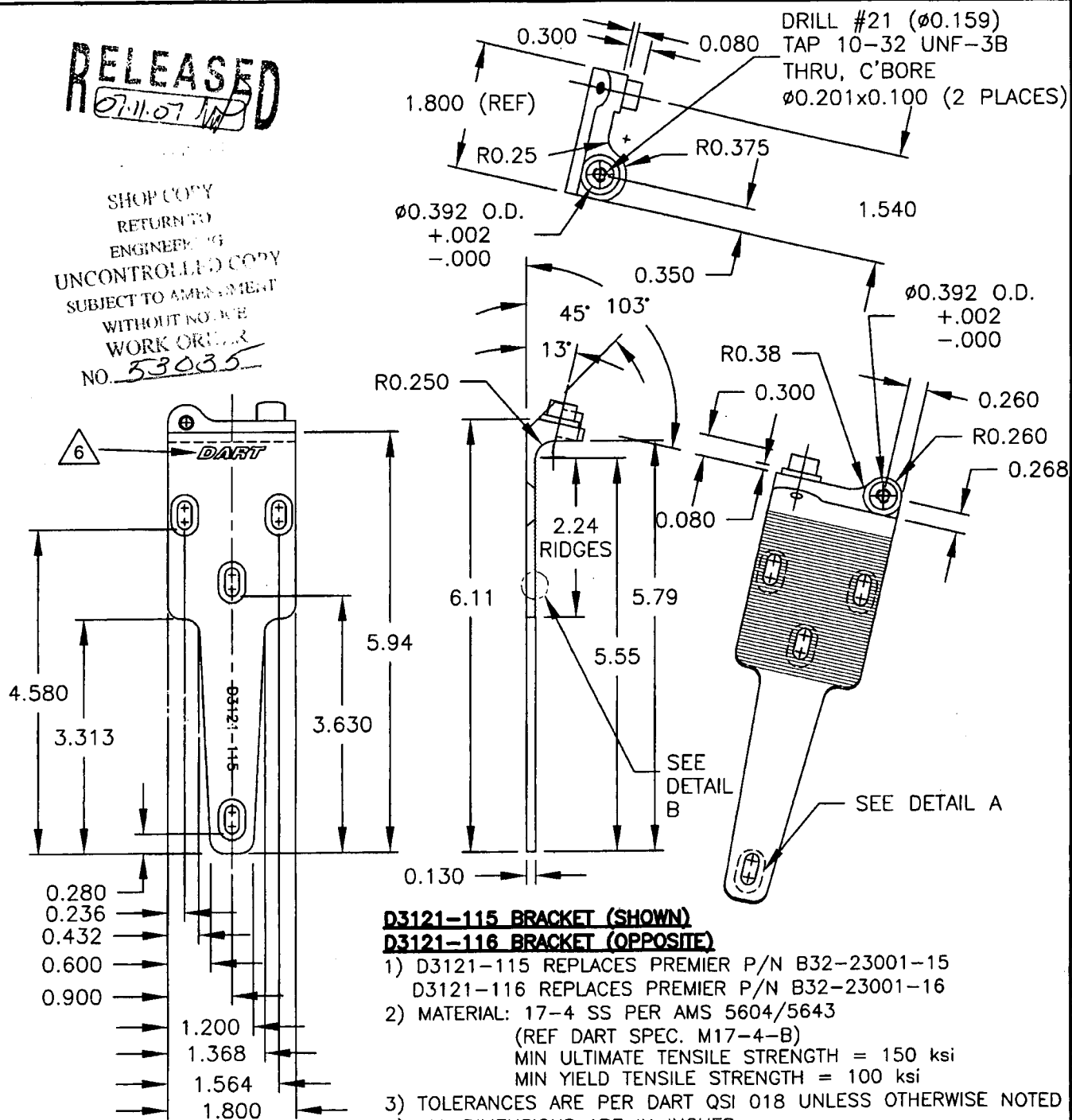
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

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07.11.07

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NO. 53035



D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

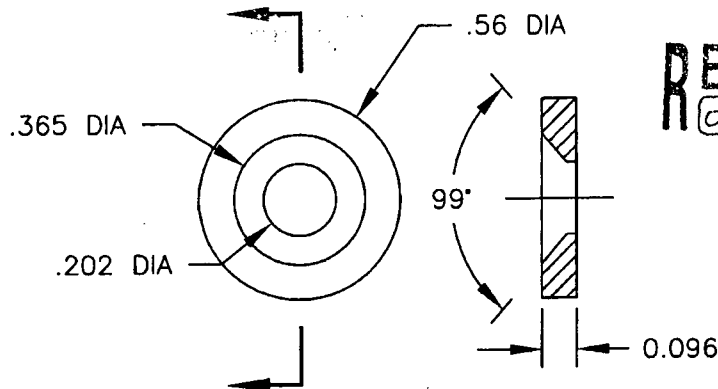
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- WITHOUT NOTICE
WORK ORDER
NO. 530.35

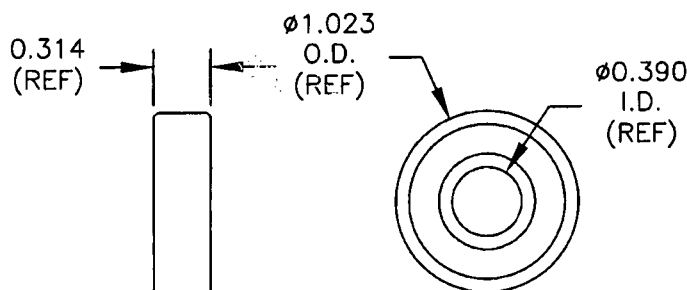
DART

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



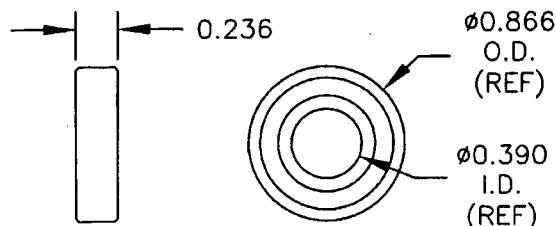
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



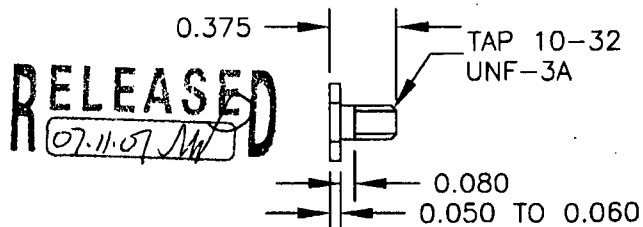
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



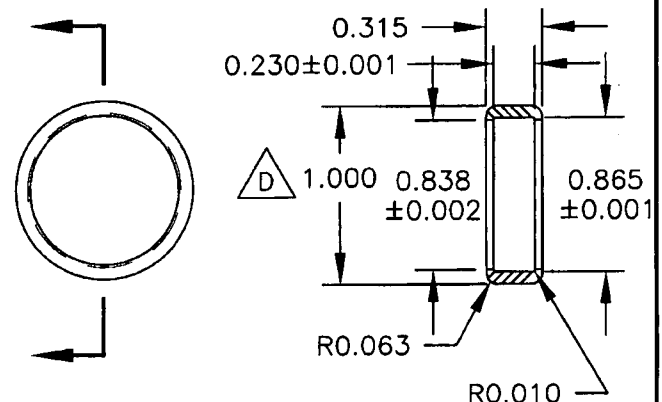
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES



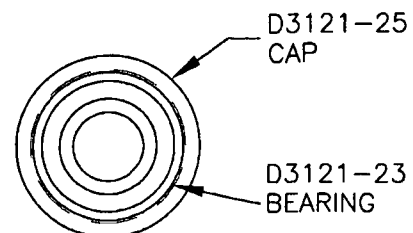
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

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